

**Work Order ID 69859**

Friday, May 20, 2011 10:40:57 AM



Page 1

Item ID: D3172-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly

Start Date: 5/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start

Approvals: Process Plan: CLDate: 11/05/20

Tooling:

Date:

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3172	Rev C
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100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut Qty 4 D3166-1 as per Dwg D3172  
2-Cut 3/4" x 3/4" square tubing as per Dwg D3172  
3-Drill holes in D3172-3 as per Dwg D3172  
4-Deburr & Remove all markings from material  
5-Weld as per Dwg D3172 using Welding Table and corner Jig & D3172T1  
6- Use DT 8996 jig to locate D3174-1 as per dwg  
7- Deburr

CL 11-06-07

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11-06-07 1 0 BE 11/06/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Page 2

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00



Subtotal

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

IX  $\phi$  M-11/06/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

K J M-L 11/06/07

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

1 BR 11-6-8

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 1

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. Finally, the fifth step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and goals to determine the effectiveness of the project and identify areas for improvement.

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

2. The second step is to analyze the problem. This involves breaking the problem down into smaller parts and understanding the causes and effects.

3. The third step is to develop a plan. This involves deciding on the best way to solve the problem and setting goals and objectives.

4. The fourth step is to implement the plan. This involves putting the plan into action and making any necessary adjustments.

5. The fifth step is to evaluate the results. This involves checking to see if the problem has been solved and if the goals and objectives have been met.

6. The sixth step is to document the process. This involves writing down what was done and how it was done, so that it can be repeated in the future.

7. The seventh step is to share the results. This involves telling others about what was done and how it was done, so that they can learn from the experience.

8. The eighth step is to review the process. This involves looking back at what was done and thinking about what could be done better next time.





9. The ninth step is to celebrate the success. This involves acknowledging the hard work and effort that went into solving the problem.

10. The tenth step is to continue to improve. This involves looking for ways to make the process even better and more efficient.

**Required Date:** 6/10/2011

**Required Qty: 1.00**

**Comments:** IPP Rev:B 04.01.05 Added Step 5 inspection KJ/RF  
IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC IPP Rev:D  
11.04.04 added pressure wash DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-117 		Manufactured	No			100	Each	20.0000	2	2			
Clevis													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				20					
					55729			20					
D2232-3 		Manufactured	No			100	Each	16.0000	2	2			
Basket Hinge													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				16					
					69211			16					
D2327-3 		Manufactured	No			100	Each	19.0000	2	2			
Spacer Bushing													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				19					
					69436			19					
D2581 		Manufactured	No			100	Each	54.0000	2	2			
Mounting Bracket													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				54					
					68964			26					
					69258			28					

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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# Picklist Print

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Work Order ID: 69859

Parent Item: D3172-041

Parent Item Name: Basket Base Assembly

Start Date: 5/20/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

D3166-1

Manufactured No

100

Each

2.0000

4

4



Basket Hoop

Location

Loc Qty

Loc Code

WA

2

66719

2

100

Each

12.0000

8

8

D3174-1

Manufactured No



Mounting Lug

Location

Loc Qty

Loc Code

WA005

12

66816

12

100

sf

506.2978

48

48

M304EX0.75-16F

Purchased No



Expanded Metal Flat SS

Location

Loc Qty

Loc Code

MAT

209.1053

117708

209.1053

WA

297.1925

115012

114

117197

167.1584

117455

16.0341

*Pl 11.06.07*

*369017 → 4*

*Pl 11.06.07*

*48*

*48.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Work Order ID: 69859



Parent Item: D3172-041



Parent Item Name: Basket Base Assembly

Start Date: 5/20/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100

f

1,321.290

51

53.68421



SAD 11-06-01

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT018

1140.8565

117598

1000

117636

140.8565

WA007

180.4339906

116267

162.707172

116763

17.7268186

53.6842

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

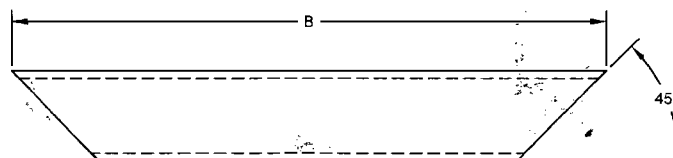
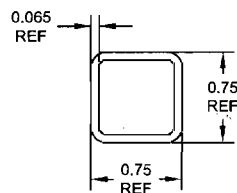
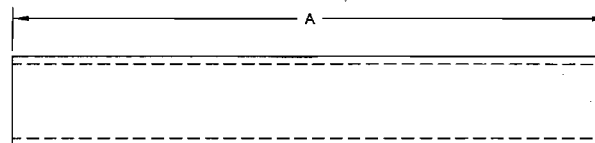
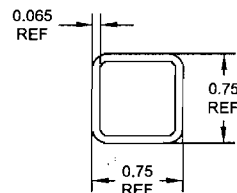
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# PARTS LIST FOR D3172-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3172-1	2	—	96.00	RIB
D3172-3	2	—	25.50	RIB
D3172-5	6	33.09	—	RIB
D3172-7	3	26.81	—	RIB
D3172-9	1	94.50	N/A	RIB
D2012-117	4	N/A	N/A	CLEVIS
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D3166-1	4	N/A	N/A	RIB
D3174-1	8	N/A	N/A	MOUNTING LUG

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69859  
CL 11/05/20



RELEASED  
08.07.03

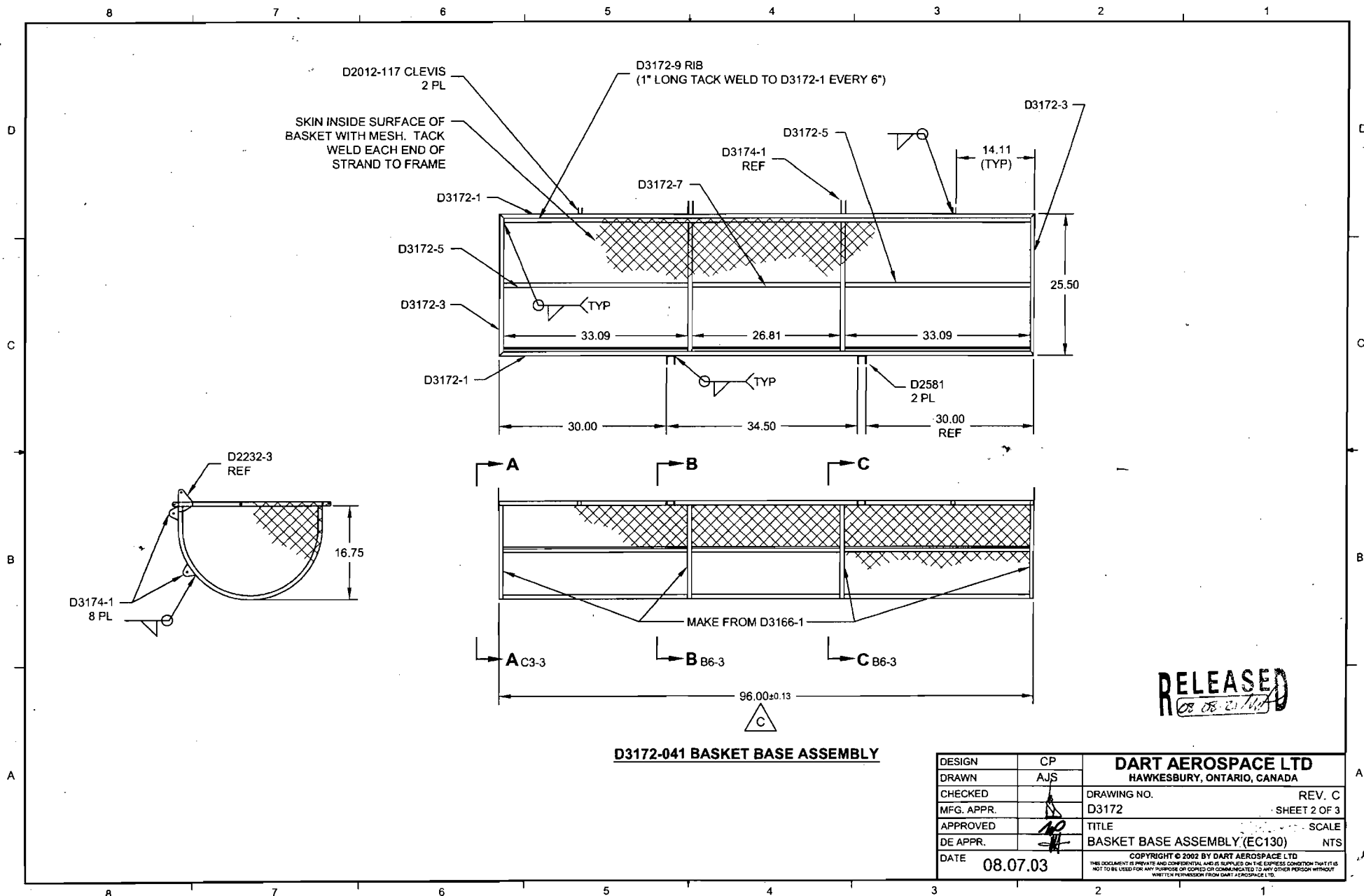


## NOTES:

- MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: NONE
- WEIGHT: N/A
- WELD PER DART QSI 004

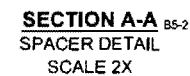
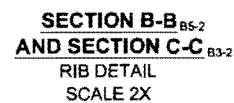
C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.03
B	ADD D3172-9 & D2012-117	CP	03.01.07
A	NEW ISSUE	DS	02.12.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3172	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (EC130)	NTS
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RELEASE  
05-05-21/114

DESIGN	CP	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. OF
MFG. APPR.		D3172	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (EC130) NTS	
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